

D206.628-033

Work Order ID 50820

July 22, 2009 4:04:53 PM

Page 1

Item ID: D2842-041

Accept

Revision ID: B

Item Name: Step Assembly, 206 Float

Start Date: 7/27/09

Start Qty: 4.00

Required Date: 7/31/09

Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2842

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 12-Drill D2842-1 using Jig DT8271 as per Dwg D2842 13-Deburr and bevel ends for welding

SAD

09-07-23

Qty
(4)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SAD 09-07-23 4

120

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab


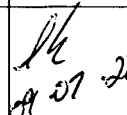
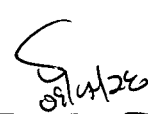
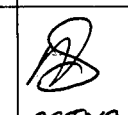


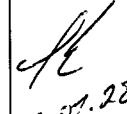

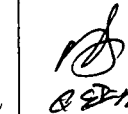

1-Weld one end cap and (2) lugs using Jig DT followed by DT as per Dwg D2842 1A/R AL Rod Batch: 1110130 2-Grind end cap weld flush

1110972

SAD 09-07-23 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2842-041 PAR #: N/A Fault Category: Large FAB NCR: Yes No DQA: Yes Date: 09.08.14
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: Yes Date: 08.08.17

NCR: <u>50820</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/28	100 Large Port	Found a small (about 1/2" wide and about 0.060" deep) dent R70375" from RWD end cap.		- fill area with weld as per QST 064 8/24 M/10/30	 09.07.28	 09/07/28	 09/07/28	 09/07/28
		RL looks like a mark from Drilling holes but no one (Pat.E. or Steven D.) knows what happens. Turns out it's a small piece of weld on plate when welding the large, caused the mark.		so it is not notice able; and the mark on the weld stand / support.	 09.07.28	 09/07/28	 09/07/28	 09/07/28

NOTE: Date & initial all entries

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Page 2

Item ID: D2842-041

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Setup Start



Revision ID: B

Stop



Item Name: Step Assembly, 206 Float

Start Date: 7/27/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4

RE 09/07/28

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 09/07/28



150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SAD 09-07-28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2842-041

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Start Date: 7/27/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/31/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

SE 09.07.29

4



QC

Memo

0.00

Quality Control

170

Large Fab

0.00



Large Fab

Memo

0.00

SE 09.07.29

4

Large Fab

1-Remove alodine prior to welding. 11 Weld end cap as per Dwg
D2842.11A/R AL Rod Batch: M110130 12-Grind end cap weld
flush.

SE SAD 09-07-29

180

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

PD 09.07.30

Quality Control

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Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

{ (+) Touch-up Alodine + pressure wash } 09-07-30 (X44) JH

Memo

0.00

Powder Coating

START TIME: 7:10am

FINISH TIME: 7:40am

OVEN TEMPERATURE: 320°F

=>

M112148

09-07-30

(X44) JH

210

QC3- Inspect Part Finish

0.00



QC

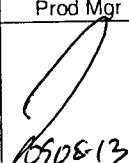
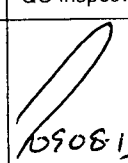

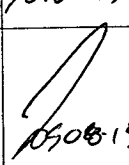
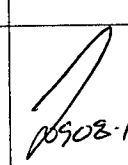
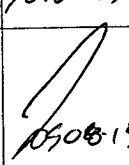
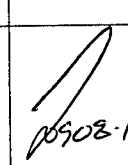
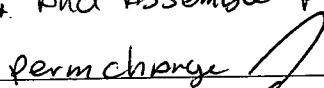
Memo

0.00

Quality Control

DR 09-07-31 (4)

1st page

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.08.13	200	Add "Touch-up step with alocine per Q31005 prior to powder coating						
		perm change 	BE	09.08.14				
09.08.13	220	Add step wing walk, m# _____, in a site flex m# _____ exp date for inserting the s. And assemble per deng.						
		Also re-route Rprt picking. perm change 	BE	09.08.14				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50820

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Item ID: D2842-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Assembly, 206 Float

Start Date: 7/27/09

Start Qty: 4.00



Cust Item ID:

Required Date: 7/31/09

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per Dwg D2842! 12-Wing Walk as per Dwg D2842 and QSI

005 4.11 Batch: M111013 wing walk

Batch: m111557 exp: 10/01 SiKaplex

(14)

ump 09/08/04

230

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

=> 8 09/08/05

(144) 6

240

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

PPP 50816

9/8/12 (42) 89

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Item ID: D2842-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Assembly, 206 Float

Start Date: 7/27/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/31/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

A

08-13

CL09/08/12

Picklist Print

July 22, 2009 4:04:52 PM

Work Order ID: 50820

Parent Item: D2842-041RevB

Parent Item Name: Step Assembly, 206 Float


Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			100 230	Each	4,758.000	12.0000			

W/O
CHG

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

4758

103585

100

112116

4658

D2622-120CRevC1  Step Extrusion		Manufactured	No			120 100	Each	157.0000	4.0000			
---	--	--------------	----	--	--	------------	------	----------	--------	--	--	--

X12 MWD 09/08/04

W/O
CHG

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

31

46910

31

Main Warehouse

WA

126

48612

126

D2734RevC  Step End Plate		Manufactured	No			120	Each	133.0000	8.0000			
---	--	--------------	----	--	--	-----	------	----------	--------	--	--	--

Qty
4 SAD 09-07-23 (4)

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

133

43535

17

48110

116

09-07-29 4+3
1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2 14

Work Order ID: 50820

Parent Item: D2842-041RevB

Parent Item Name: Step Assembly, 206 Float


Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3459-1RevA		Manufactured	No			220 120	Each	26.0000	8.0000			
												
Float Step Mounting Plate												

W/O
CHG

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 6

46987 6

Main Warehouse

WA 20

48138 20

D3459-3RevA Manufactured No



Float Step Mounting Plate

120 Each 23.0000 8.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 23

46866 6

46988 17

109.07.28 8

109.07.28 8

July 22, 2009 4:04:52 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 50820

Parent Item: D2842-041RevB

Parent Item Name: Step Assembly, 206 Float

Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS27039C1-07

Purchased

No

220

Each

70.0000

12.0000



screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

70

107008

1

111424

69

uno 09/08/09

NAS1329C3KB130

Purchased

No

220

Each

122.0000

12.0000



insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

122

110117

22

111981

100

uno 09/08/09

July 22, 2009 4:04:53 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 22, 2009 4:04:53 PM

Work Order ID: 50820

Parent Item: D2842-041RevB

Parent Item Name: Step Assembly, 206 Float



Comments:

Start Date: 7/27/09

Required Date: 7/31/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L  WASHER		Purchased	No			220	Each	374.0000	12.0000 			

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	334	
110450	2	
110806	32	
111819	300	

umo 09/08/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

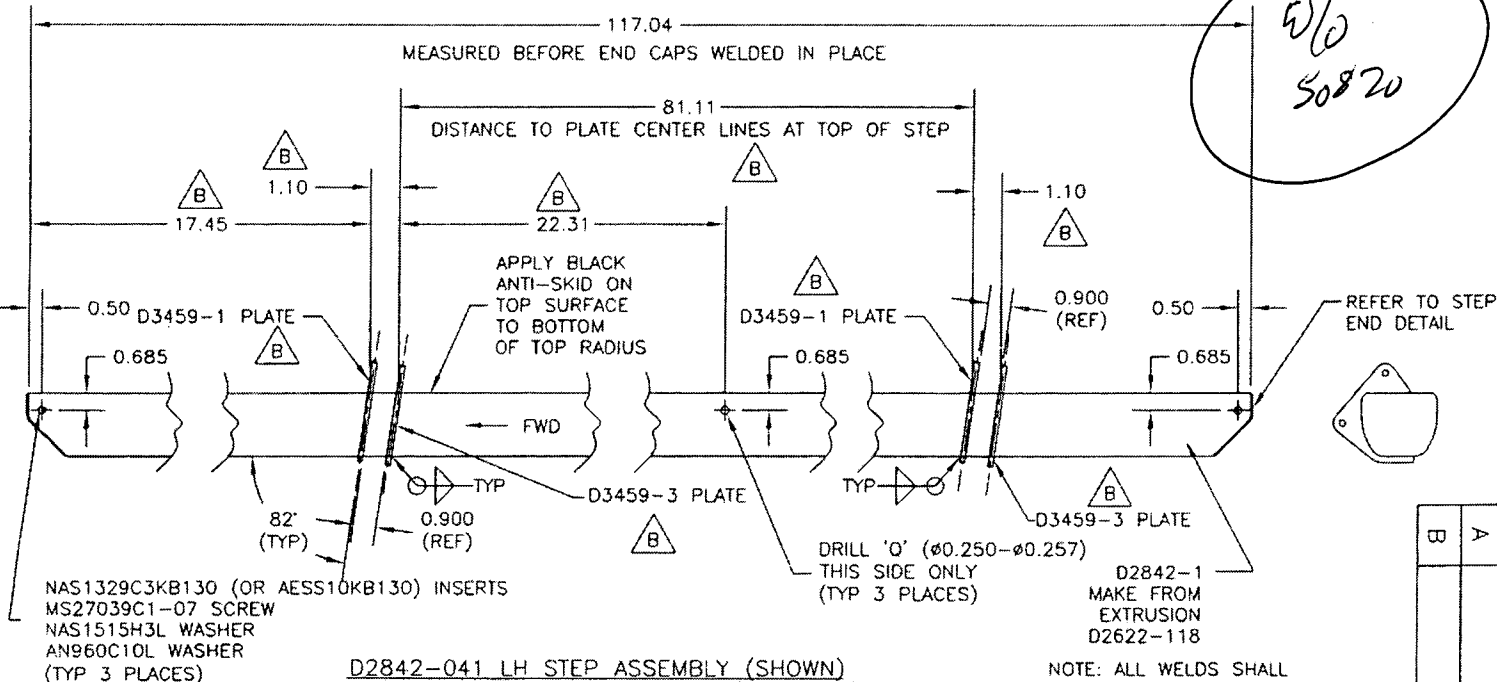
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

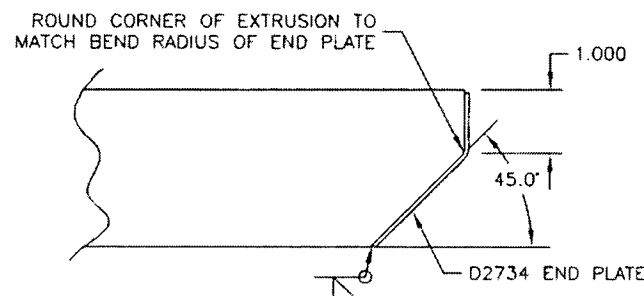
DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
DATE	DATE	206L/407 FLOAT STEP ASSEMBLY
05.09.23	98.10.13	NEW ISSUE
A	05.09.23	RE-DESIGN, ADD D3459-1/-3
B		
SCALE	NTS	



D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05/11/14